

Work Order ID 79226

January-24-12 9:54:27 AM

\*79226\*

Page 1

Item ID: D2933-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Saddle LH In, 206  
 Start Date: 24/01/2012 Start Qty: 8.00 \*8\* Cust Item ID:  
 Required Date: 10/02/2012 Req'd Qty: 8.00 \*8\* Customer:  
 Reference:

Approvals: Process Plan: M.L.J. Date: 12/01/24 Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2933	Rev C								

100 HAAS CNC VERTICAL MACHINING #1 0.00  
 \*100\* HAAS 1 0.00  
 HAAS CNC vertical machine #1

**Memo**

Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per

110 CONVENTIONAL MILLING MACHINE 0.00  
 \*110\* Mill Conv 0.00  
 Conventional Milling Machine

**Memo**

Machine Keyway and inspect per attached dimension sheet

120 QC1- Inspect dimensions to dimension sheet 0.00  
 \*120\* QC 0.00  
 Quality Control

**Memo**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 79226

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Item ID: D2933-1      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
Revision ID:      Stop **\*NS2\***  
Item Name: Saddle LH In, 206  
Start Date: 24/01/2012      Start Qty: 8.00      **\*8\***      Cust Item ID:  
Required Date: 10/02/2012      Req'd Qty: 8.00      **\*8\***      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00	<i>ask 12/02/06</i>			<u>3</u>	<u>0</u>		
140 <b>*140*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				<u>8</u>	<u>14</u>	<u>12-2-6</u>	
155 <b>*155*</b> SprayPaint Spray Painting	  Memo PRIME B <u>117319</u> DELFLEET BLUE B <u>118395</u> CLEAR DELFLEET B <u>118093</u>	0.00  0.00				<u>18</u>	<u>12-2-11</u>	<u>(8) PTO</u>	<u>→</u>

W/O:		B 79226						WORK ORDER CHANGES	
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

Part No: D2933-1 PAR #: \_\_\_\_\_ Fault Category: Finishing/wet paint NCR: Yes No DQA: [Signature] Date: 12/2/14  
 Resolution: Rework Disposition: Rework QA: N/C Closed: [Signature] Date: 12/2/14

NCR: <u>12-1204</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12-2-9	#155	Paint has too many flaws in it R.C. Painter tried to paint too many parts at once	S [Signature] 02/02/14	scuff qty x 5  Re paint as per QSI005 in small batches	AS 12-2-9	[Signature] 12-02-13	S [Signature] 02/02/14	S [Signature] 12/02/14

NOTE: Date & initial all entries

# Work Order ID 79226

**\*79226\***

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January-24-12 9:54:27 AM

Item ID: D2933-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle LH In, 206  
 Start Date: 24/01/2012 Start Qty: 8.00 **\*8\*** Cust Item ID:  
 Required Date: 10/02/2012 Req'd Qty: 8.00 **\*8\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
165	QC14- Inspect Spray Paint	0.00							
<b>*165*</b>									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location. <u>621</u>	0.00							
<b>*170*</b>									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

*12/02/13*  
*(S)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January-24-12 9:54:33 AM

Page 1

Work Order ID: 79226

\*79226\*

Parent Item: D2933-1

\*D2933-1\*

Parent Item Name: Saddle LH In, 206

Start Date: 24/01/2012

Required Date: 10/02/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: B00.06.26New DWG rev (mpp 2069)EC  
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-001		Manufactured	No			100	Each	154.0000	1	8			
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\*D6101-001\*

Saddle Billet

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B.A 12/02/02

Location

Loc Qty

Loc Code

MAT040

94

69677

2

73774

11

76836

1

→78158

80

8.0

MAT41

60

78598

60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	79226
<b>Description:</b> 206 Saddle, Inboard, Left side		<b>Part Number:</b>	D2933-1
<b>Inspection Dwg:</b> D2933 <b>Rev:</b> C <b>DSK:</b> <b>Rev:</b>		Page 1 of 1	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.100	0.140		0.134	0.128	0.128	0.128	0.129
B	0.100	0.140		0.136	0.127	0.127	0.127	0.128
C	0.100	0.140		0.114	0.114	0.117	0.120	0.118
D	0.210	0.230		0.223	0.223	0.225	0.225	0.225
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.249	1.250	1.250	1.250	1.250
G	2.495	2.505		2.495	2.500	2.500	2.500	2.500
H	0.510	0.515		0.512	0.512	0.512	0.512	0.512
I	1.572	1.582		1.575	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		0.2575	0.260	0.260	0.260	0.260
L	0.312	0.317		0.316	0.314	0.314	0.314	0.314
M	0.235	0.240		0.237	0.237	0.237	0.237	0.237
N	0.100	0.140		0.124	0.123	0.125	0.125	0.125
O	0.540	0.560		0.549	0.548	0.548	0.548	0.548
P	0.490	0.510		0.5005	0.497	0.497	0.497	0.497
Q	3.715	3.725		3.721	3.720	3.720	3.720	3.720
R	2.470	2.510		2.491	2.490	2.490	2.490	2.490
S	0.240	0.270		0.255	0.253	0.253	0.253	0.253
T	0.100	0.180		0.140	0.135	0.135	0.135	0.135
U	1.625	1.635		1.627	1.630	1.630	1.630	1.630
V	1.362	1.372		1.3655	1.367	1.367	1.367	1.367
W	0.316	0.321		0.316	0.316	0.316	0.316	0.316
X	1.125	1.145		1.1358	1.135	1.137	1.137	1.137
Y	1.565	1.585		1.574	1.572	1.575	1.575	1.576
Z	0.178	0.198		0.188	0.188	0.188	0.188	0.188
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

<b>Measured by:</b>	H 12/02/01 / B.A 12/02/02	<b>Date:</b>	12/02/01
<b>Audited by:</b>	CMX	<b>Date:</b>	12/02/06
<b>Prototype Approval:</b>	N/A	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	79226
Description: 206 Saddle, Inboard, Left side				Part Number:	D2933-1
Inspection Dwg: D2933 Rev: C DSK: Rev:				Page 1 of 1	

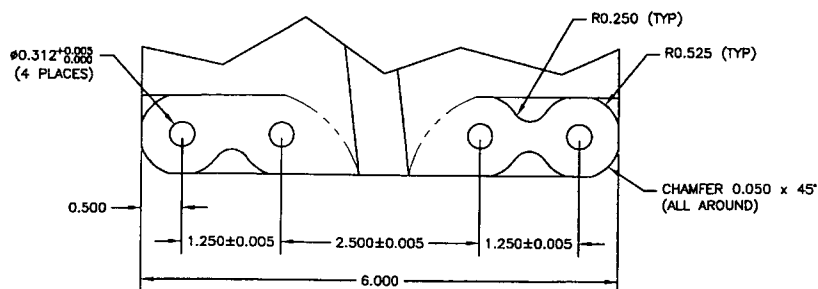
### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	4	5
A	0.100	0.140		0.129	0.129	0.129		
B	0.100	0.140		0.128	0.127	0.128		
C	0.100	0.140		0.117	0.116	0.116		
D	0.210	0.230		0.225	0.225	0.225		
E	1.245	1.255		1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250		
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M	0.235	0.240		0.237	0.237	0.237		
N	0.100	0.140		0.125	0.125	0.125		
O	0.540	0.560		0.548	0.548	0.548		
P	0.490	0.510		0.497	0.495	0.498		
Q	3.715	3.725		3.720	3.720	3.720		
R	2.470	2.510		2.490	2.490	2.490		
S	0.240	0.270		0.254	0.254	0.254		
T	0.100	0.180		0.135	0.135	0.135		
U	1.625	1.635		1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367		
W	0.316	0.321		0.316	0.316	0.316		
X	1.125	1.145		1.136	1.136	1.136		
Y	1.565	1.585		1.576	1.576	1.576		
Z	0.178	0.198		0.188	0.188	0.188		
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

Measured by: B.A	Date: 12/02/02
Audited by: [Signature]	Date: 12/02/06
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	[Signature]

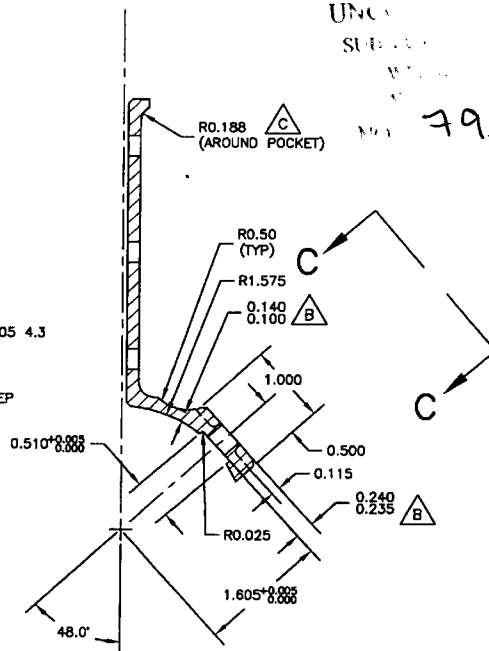


VIEW C-C

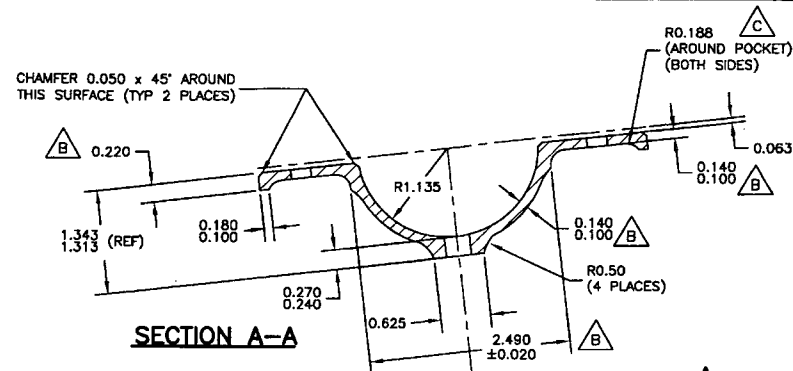
D2933-1 LH SADDLE (SHOWN)  
D2933-2 RH SADDLE (OPPOSITE)

NOTES:

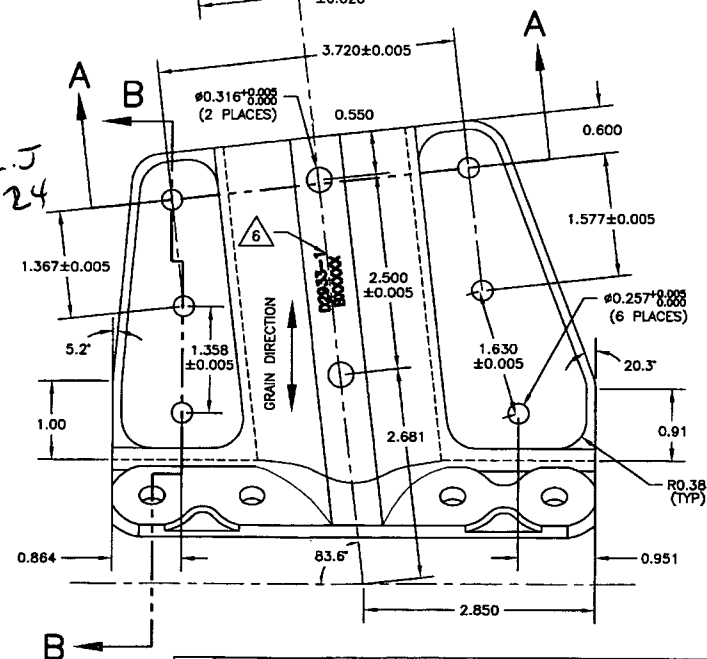
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SECTION B-B



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	BY	DRAWN BY
CHECKED	BY	APPROVED
DATE	06.11.09	
DRAWING NO.	D2933	
TITLE	SADDLE INSIDE	
REV. C		
SHEET 1 OF 1		
SCALE		
2:3		

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**DART** DART AEROSPACE USA, INC.  
BELLEVUE, WA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries